

split Blue Feb. 15

Work Order ID 79235 -1

79235

Page 1

January-24-12 9:56:39 AM

Item ID: D3414-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: 12 split Stop *NS2*
 Item Name: Lug Assembly
 Start Date: 24/01/2012 Start Qty: 40.00 *40* Cust Item ID:
 Required Date: 10/02/2012 Req'd Qty: 40.00 *40* Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/24 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3414	Rev C

100 0.00

100

Waterjet

FLOW CNC Waterjet

304.100

Memo

1-Cut as per Dwg D3414-1

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

0.00

B12-1-26

(44)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

B12-1-2C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 79235

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Item ID: D3414-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Lug Assembly

Start Date: 24/01/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 10/02/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

0.00

130

Brake NC

Memo

0.00

Brake NC

1-Debur

2-Form using DT8254 as per Dwg D3414

140

0.00

140

Large Fab

Memo

0.00

Large Fab

1- Weld using location Jig DT9625 as per Dwg D3414

A/R S.S. welding rod Batch: 116577

W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 QC9- Inspect visual per QSI004- Fusion Welds 0.00

150

QC

Quality Control

Memo

0.00

12-02-16 (40)

160 QC5- Inspect part completeness to step on W/O 0.00

160

QC

Quality Control

Memo

0.00

8/21/16

counts

(40)

175 0.00

175

SprayPaint

Spray Painting

Memo

0.00

PRIME B 117319
 DELFLEET BLUE B 118395
 CLEAR DELFLEET B 118093

85 12-02-21 (12)

W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
185 *185* QC Quality Control	QC14- Inspect Spray Paint Memo	0.00 0.00				12	12	02	22 (12)
190 *190* Packaging Packaging	Identify as per dwg & Stock Location. 420 Memo	0.00 0.00				10/2/22	12		12
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				12/02/23			ME 12-02-22

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Picklist Print

January-24-12 9:56:42 AM

Page 1

Work Order ID: 79235

79235

Parent Item: D3414-041

D3414-041

Parent Item Name: Lug Assembly

Start Date: 24/01/2012

Required Date: 10/02/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S12GA		Purchased	No			100	sf	131.3300	0.155	6.2			

M304S12GA

304/316 0.100" Sheet

**

B12-1-28

Location

Loc Qty

Loc Code

MAT019

131.33

113062

117.1

113077

14.23

D3414-3

Manufactured

No

140

Each

0.0000

1

40

D3414-3

Lug

**

Pl 12.02.15

B78923 → 40x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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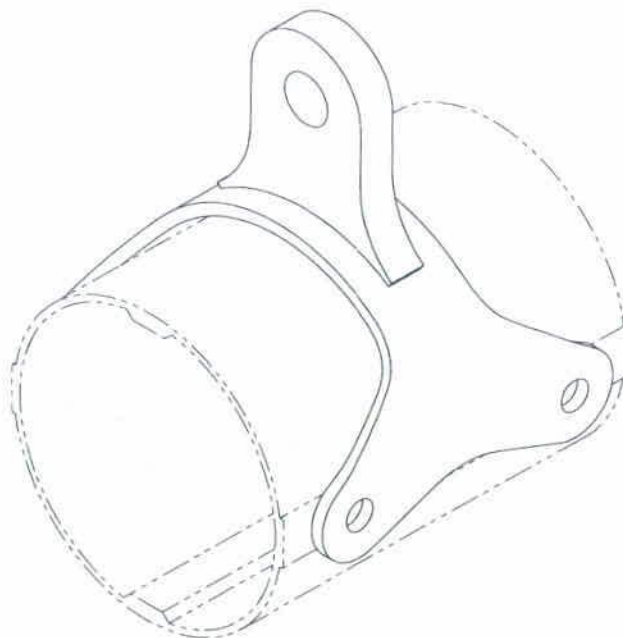
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ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG



D3414-041 LUG ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

79235 M.L.J
12/01/24

RELEASED
5/16/2024

C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.050 WAS 0.010-0.030 (ZN A7-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	CP	DRAWING NO.	REV. C
MFG. APPR.	CP	D3414	SHEET 1 OF 3
APPROVED	CP	TITLE	SCALE
DE APPR.	CP	LUG ASSEMBLY	NTS
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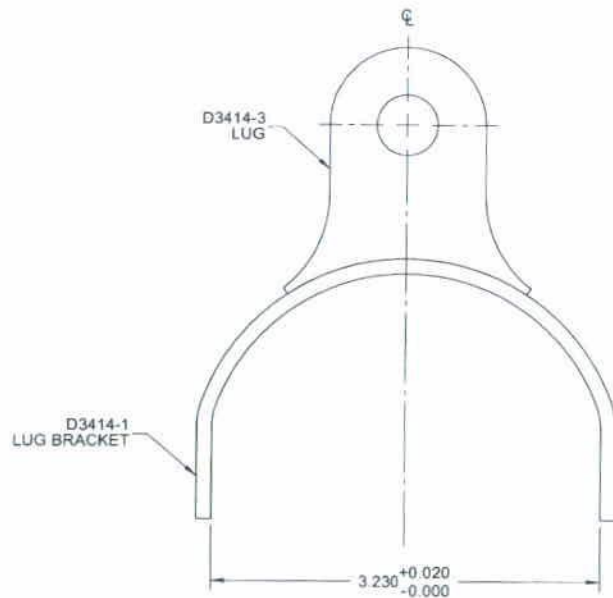
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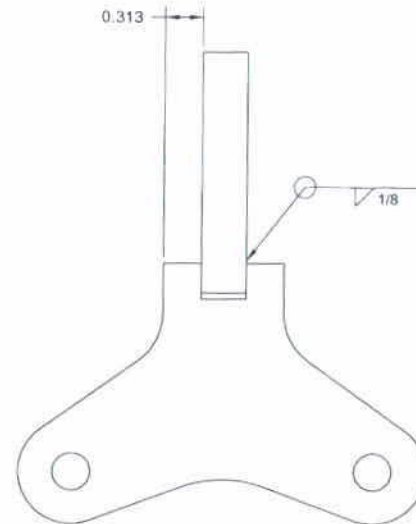
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79235



D3414-041 LUG ASSEMBLY



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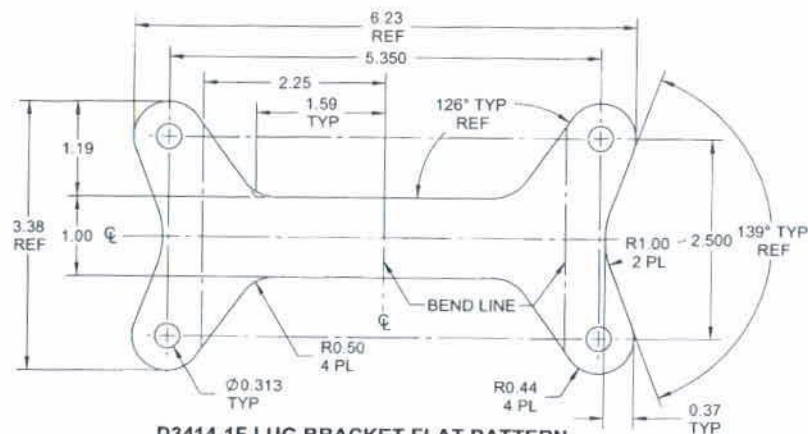
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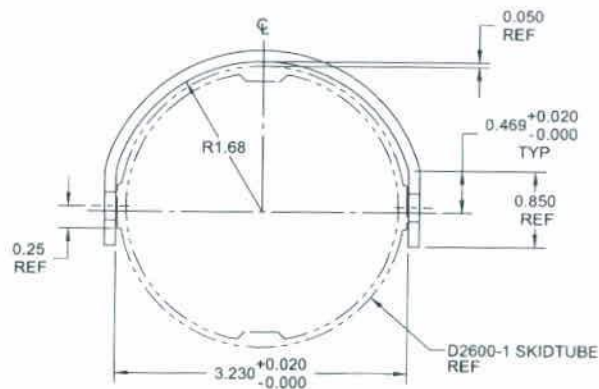
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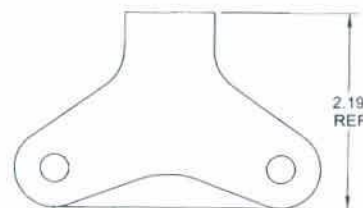
79235



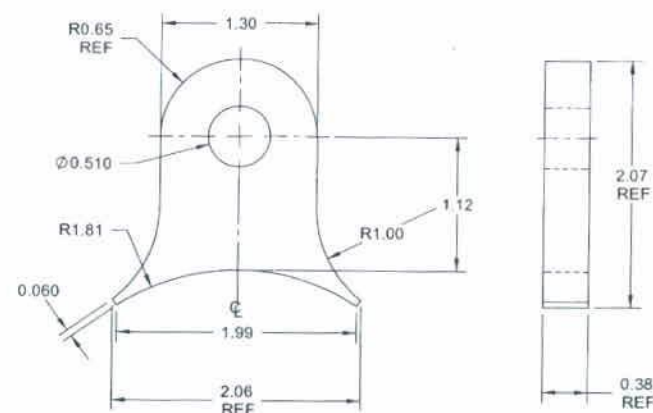
D3414-1F LUG BRACKET FLAT PATTERN



D3414-1 LUG BRACKET



SIDE VIEW FOR REF ONLY



D3414-3 LUG

- NOTES:
1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S12GA
-3: AISI 304/316 STAINLESS STEEL PLATE
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX
-3: 0.030 TO 0.060 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

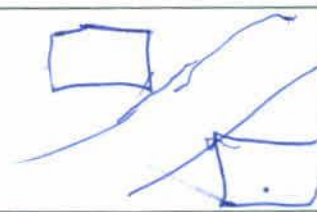
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DRAWN	CP		
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MFG. APPR.		TITLE LUG ASSEMBLY	SHEET 3 OF 3
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